

Work Order ID 133984

Tuesday, June 23, 2015 3:26:35 PM

133984

Page 1

Item ID: D119-827-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Tail Rotor Pedal Lockout

Stop *NS2*

Start Date: 6/18/15 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 6/23/15 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** MLJ **Date:** JUN 24 2015 **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop
NR2

[illegible]

JUN 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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133984

Page 2

Item ID: D119-827-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Rotor Pedal Lockout

Start Date: 6/18/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/23/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-827-011								
	Location: <u>121</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

JUL 02 2015

DAS
6
2.00

MLJ

JUL 02 2015

MLJ JUL 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 133984

133984

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 6/18/15

Required Date: 6/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS IPP
REV:B 13-01-09 REV B JLM VERIFIED:DD IPP REV:C
12.10.16 as per CHG002 (ecn 13-538) DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4704-041		Manufactured	No			110	Each	1.0000	1	1			
D4704-041									**			DAS	DAS
Expandable Pin Assembly												27	26
	DAS											9-89	9-89
	02												
	9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST123				1					
				129966				1					
D4703-041		Manufactured	No			110	Each	6.0000	2	2			
D4703-041									**			DAS	DAS
Lock Pin Assembly												27	26
	DAS											9-89	9-89
	02												
	9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST123				6					
				127873				6					
D4710-1		Manufactured	No			110	Each	9.0000	1	1			
D4710-1									**			DAS	DAS
Spacer												27	26
	DAS											9-89	9-89
	02												
	9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST123				9					
				127249				9					
D4721-1		Manufactured	No			110	Each	6.0000	1	1			
D4721-1									**			DAS	DAS
Decal												27	26
	DAS											9-89	9-89
	02												
	9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST121				4					
				127250				4					
				ST124				2					
				121659				2					

JUN 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Work Order ID: 133984

133984

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 6/18/15

Required Date: 6/23/15

Start Qty: 1.00

Required Qty: 1.00

AN4-11A Purchased No 110 Each 225.0000 2 2

AN4-11A

BOLT

DAS
02
9-89

Location

Loc Qty

Loc Code

FG 20
120731 20
ST325A 205
11921 1
M128362 203
M128769 1

**

DAS
27
9-89

DAS
26
9-89

MS14144L4 Purchased No 110 Each 3.0000 2 2

MS14144L4

Nut

DAS
02
9-89

Location

Loc Qty

Loc Code

ST316 3
m131234 3

**

DAS
27
9-89

DAS
26
9-89

MS24665-153 Purchased No 110 Each 83.0000 2 2

MS24665-153

Cotter Pin

DAS
02
9-89

Location

Loc Qty

Loc Code

ST294 83
107139 83

**

DAS
27
9-89

DAS
26
9-89

NAS1149D0416J Purchased No 110 Each 4,785.0000 2 2

NAS1149D0416J

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

ST270 4785
m131511 4785

**

DAS
27
9-89

DAS
26
9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
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Picklist Print

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Work Order ID: 133984

133984

Parent Item: D119-827-011

D119-827-011

Parent Item Name: Tail Rotor Pedal Lockout

Start Date: 6/18/15

Required Date: 6/23/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

4,030.000

8

8

NAS1149D0463J

WASHER

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

708

M132317

708

ST269

3281

M129682

86

M130799

371

M132035

2824

**

DAS
27
9-89

DAS
26
9-89

NAS6604D16

Purchased

No

110

Each

45.0000

2

2

NAS6604D16

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

ST262

45

m131616

45

**

DAS
27
9-89

DAS
26
9-89

JUN 25 2015

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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☐ Crimp/Kink/Ripple/Wave																																																																									
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☐ Crushing																																																																									
☐ Heat Treat																																																																									
☐ Wave/Twist in Tube																																																																									
☐ Marks/Chatter																																																																									
☐ Temperature/Cure																																																																									
☐ Set-up																																																																									
☐ BOM/Route																																																																									
☐ Broken/Damage/Defect																																																																									
☐ Inspection Incomplete/Unqualified																																																																									
☐ Contamination																																																																									
☐ Countersink																																																																									
☐ Cut Too Short																																																																									
☐ Instructions Incomplete/Unclear																																																																									
☐ Drill Holes																																																																									
☐ Power Loss/Surge																																																																									
☐ Folio/Program																																																																									
☐ Grain																																																																									
☐ Weld																																																																									
☐ Wrong Stock Pulled																																																																									
☐ Out of Sequence																																																																									
☐ Off-set																																																																									
☐ Misabeled																																																																									
☐ Fit/Function																																																																									
☐ Misaligned/off center																																																																									
☐ Positioned Wrong																																																																									
☐ Outside Dimensions																																																																									
☐ Over/Under tolerance																																																																									
☐ Part Incorrect																																																																									
☐ Part Lost/Missing																																																																									
☐ Part Moved																																																																									
☐ Drawing																																																																									
☐ Finish																																																																									
☐ Misread																																																																									
☐ Turning Sequence																																																																									
OTHER : _____																																																																									

REFERENCE ONLY**4.0 PARTS LIST**

-011	Part Number	Description
X	D119-827-011	TAIL ROTOR PEDAL LOCKOUT
1	D4704-041	EXPANDABLE PIN ASSY
2	D4703-041	LOCKOUT PIN ASSY
1	D4710-1	SPACER
1	D4721-1	DECAL
2	AN4-11A	BOLT
2	MS14144L4	NUT
2	MS24665-153	COTTER PIN
2	NAS1149D0416J	WASHER
8	NAS1149D0463J	WASHER
2	NAS6604D16	BOLT

5.0 WEIGHT AND BALANCE

The following are the net weight increases associated with D119-827-011 kit.

Installation	Weight	Longitudinal		Lateral	
		Arm	Moment	Arm	Moment
D119-827-011 ON A109/A119 MODELS	0.52 lb 0.23 kg	32.6 in 0.83 m	16.9 in-lb 0.19 m-kg	-13.1 in -0.33 m	-6.8 in-lb -0.08 m-kg
D119-827-011 ON 206/407 MODELS	0.52 lb 0.23 kg	33.0 in 0.84 m	17.2 in-lb 0.19 m-kg	-12.5 in -0.32 m	-6.5 in-lb -0.07 m-kg